

USSN: 09/757,175  
Atty. Docket No.: 10234/2  
Amdt. dated March 22, 2004  
Reply to Office Action of January 21, 2004

### AMENDMENTS TO THE CLAIMS

This listing of claims will replace all prior versions and listings of claims in the application:

#### **LISTING OF CLAIMS:**

Claim 1 (previously presented): A multi-layered colored polymeric film comprising:

- (a) an opaque core layer comprising a thermoplastic material, said core layer having a first side and a second side; and
  - (b) a first skin layer comprising a thermoplastic material with a coloring agent, wherein said first skin layer is adjacent to the first side of the core layer;
- wherein each layer of said film is substantially free of voids.

Claim 2 (canceled).

Claim 3 (original): The film of claim 1 wherein the core layer comprises from about 1.5% to about 15% by weight of TiO<sub>2</sub>.

Claim 4 (currently amended): The film of ~~claim 2~~ claim 1 wherein the core layer comprises from about 1.5% to about 15% by weight of TiO<sub>2</sub>.

Claim 5 (currently amended): The film of ~~claim 2~~ claim 1 wherein the core layer comprises isotactic polypropylene.

Claims 6-7 (canceled).

Claim 8 (withdrawn): A multi-layered colored thermoplastic film comprising:

- (a) an opaque core layer comprising a thermoplastic material, said core layer having a first side and a second side;
- (b) a first transition layer comprising a thermoplastic material, said first transition layer having a first side and a second side, wherein the first transition layer

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comprises a coloring agent and the second side of the first transition layer is adjacent to the first side of the core layer;

- (c) a first skin layer comprising a thermoplastic material, said first skin layer having a first side and a second side, wherein the second side of the first skin layer is adjacent to the first side of the first transition layer.

Claim 9 (withdrawn): The film of claim 8 further comprising a second skin layer having a first side and a second side wherein the first side of the second skin layer is adjacent to the second side of the core layer.

Claim 10 (withdrawn): The film of claim 8 further comprising a second transition layer having a first side and a second side wherein the first side of the second transition layer is adjacent to the second side of the core layer and a second skin layer having a first side and a second side wherein the first side of the second skin layer is adjacent to the second side of the second transition layer.

Claim 11 (withdrawn): The film of claim 8 wherein the core layer comprises a stratum of voids; positioned at least substantially within at least a substantial number of each of said voids, is at least one spherical void-initiating particle which is phase distinct and incompatible with said matrix material, the void space occupied by said particle being substantially less than the volume of said void, with one generally cross-sectional dimension of said particle at least approximating a corresponding cross-sectional dimension of said void.

Claim 12 (withdrawn): The film of claim 11 wherein the core layer comprises void-initiating particles of polybutylene terephthalate.

Claim 13 (withdrawn): The film of claim 12 wherein the first skin layer is substantially transparent and an image is printed on the first side of the first skin layer.

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Claim 14 (withdrawn): The film of claim 12 wherein the first skin layer comprises inorganic additives.

Claim 15 (withdrawn): The film of claim 14 wherein the inorganic additives in the first skin layer is a material selected from the group consisting of calcium carbonate, titanium dioxide, talc, and silica.

Claim 16 (withdrawn): The film of claim 12 further comprising inorganic additives in the first transition layer selected from the group consisting of calcium carbonate, titanium dioxide, talc, and silica.

Claim 17 (withdrawn): The film of claim 10 wherein the core layer comprises a strata of voids; positioned at least substantially within at least a substantial number of each of said voids, is at least one spherical void-initiating particle which is phase distinct and incompatible with said matrix material, the void space occupied by said particle being substantially less than the volume of said void, with one generally cross-sectional dimension of said particle at least approximating a corresponding cross-sectional dimension of said void.

Claim 18 (withdrawn): The film of claim 17 wherein the core layer comprises void-initiating particles of polybutylene terephthalate.

Claim 19 (withdrawn): The film of claim 18 wherein the first skin layer is substantially transparent and an image is printed on the first side of the first skin layer.

Claim 20 (withdrawn): The film of claim 19 wherein the second skin layer is substantially transparent and an image is printed on the second side of the second skin layer.

Claim 21 (withdrawn): The film of claim 18 further comprising inorganic additives in the first skin layer selected from the group consisting of calcium carbonate, titanium dioxide, talc, and silica.

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Claim 22 (withdrawn): The film of claim 21 further comprising inorganic additives in the second skin layer selected from the group consisting of calcium carbonate, titanium dioxide, talc, and silica.

Claim 23 (withdrawn): The film of claim 22 wherein the first transition layer is brown and the second transition layer is white.

Claim 24 (withdrawn): The film of claim 10 further comprising a coloring agent in the second transition layer.

Claim 25 (withdrawn): The film of claim 17 further comprising a coloring agent in the second transition layer.

Claim 26 (withdrawn): The film of claim 18 further comprising a coloring agent in the second transition layer.

Claim 27 (currently amended) A method of producing [[a]] the multi-layered colored thermoplastic film of claim 1 comprising the steps of:

- (a) coextruding a first skin layer comprising a thermoplastic material with a coloring agent adjacent to an opaque core layer made of a thermoplastic material;
- (b) orienting said first skin layer and said opaque core layer in the machine direction at an elevated temperature;
- (c) orienting said first skin layer and opaque core layer in the transverse direction at an elevated temperature.

Claim 28 (canceled).

Claim 29 (original): The film of claim 2 wherein the core layer comprises a material selected from the group consisting of high density polyethylene and linear low density polyethylene.

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Claim 30 (canceled).

Claim 31 (previously presented): A multi-layered colored thermoplastic film comprising:

- (a) an opaque core layer comprising a thermoplastic material, said core layer having a first side and a second side;
- (b) a first transition layer comprising a thermoplastic material, said first transition layer having a first side and a second side, wherein the second side of the first transition layer is adjacent to the first side of the core layer; and
- (c) a first skin layer comprising a thermoplastic material, said first skin layer having a first side and a second side, wherein the first skin layer comprises a coloring agent, and the second side of the first skin layer is adjacent to the first side of the first transition layer;

wherein each layer of said film is substantially free of voids.

Claim 32 (original): The film of claim 31 further comprising a second skin layer having a first side and a second side wherein the first side of the second skin layer is adjacent to the second side of the core layer.

Claim 33 (original): The film of claim 31 further comprising a second transition layer having a first side and a second side wherein the first side of the second transition layer is adjacent to the second side of the core layer and a second skin layer having a first side and a second side wherein the first side of the second skin layer is adjacent to the second side of the second transition layer.

Claim 34 (original): The film of claim 32 wherein the second skin layer comprises a coloring agent.

Claim 35 (original): The film of claim 33 wherein the second skin layer comprises a coloring agent.

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Claim 36 (original): The film of claim 1 wherein the first skin layer has a percent opacity less than about 40% and a percent light transmission greater than about 65%.

Claim 37 (withdrawn): The film of claim 8 wherein the combination of the first skin layer and the first transition layer has a percent opacity less than about 40% and a percent light transmission greater than about 65%.

Claim 38 (previously presented): A multi-layered colored thermoplastic film comprising:

- (a) an opaque core layer comprising a thermoplastic material, said core layer having a first side and a second side;
- (b) a first transition layer comprising a thermoplastic material, said first transition layer having a first side and a second side wherein the second side of the first transition layer is adjacent to the first side of the core layer; and
- (c) a first skin layer comprising a thermoplastic material, said first skin layer having a first side and a second side wherein the second side of the first skin layer is adjacent to the first side of the first transition layer;

wherein the multi-layered colored thermoplastic film further comprises a coloring agent in one layer selected from the group consisting of the first transition layer and the first skin layer, and each layer of said film is substantially free of voids.